

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006212**Date Inspected:** 15-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Liken & Ma Yun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 52 located on PCMK SSD1-FCSA3-1B/C.

Welder is identified as Mr. Zhang Ronghong (049225). ZPMC QC is identified as Mr. Chen Liken.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-P5-F.

SMAW welding of weld joint 51 located on PCMK SSD1-FCSA3-1B/C.

Welder is identified as Mr. Yuan Lei Lei (040324). ZPMC QC is identified as Mr. Chen Liken.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-P5-F.

South Tower Lift 3

FCAW welding of weld joint 11 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Zhang Yigui (048627). ZPMC QC is identified as Mr. Chen Liken.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 10 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Yu Yonglai (048378). ZPMC QC is identified as Mr. Chen Liken.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

South Tower Lift 1

FCAW welding of weld joint 124B located on PCMK SSD1-A111B/H.

Welder is identified as Mr. Fei Chen Xiang (066239). ZPMC QC is identified as Mr. Chin Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-Repair.

SMAW welding of weld joint 155 located on PCMK SSD1-A164D/J.

Welder is identified as Mrs. Shen Mei (041716). ZPMC QC is identified as Mr. Chin Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4312.

Repair work on plate bevel

SMAW welding at bevel end on plate PCMK P325-1A.

Welder is identified as Mr. Chen Qiqiong (056364). ZPMC QC is identified as Mr. Chin Liken.

The welding variables recorded by QC appeared to comply with WPS-345-2G (2F)-Repair.

SMAW welding at bevel end on plate PCMK P325-1A.

Welder is identified as Mrs. Li Jixiang (053829). ZPMC QC is identified as Mr. Chin Liken.

The welding variables recorded by QC appeared to comply with WPS-345-2G (2F)-Repair.

This QA Inspector observed deep grind gouges on Skin E stiffener 105 between diaphragms 28M and 33M.

QA Inspector informed ZPMC Shop Foreman Mr. Liu Yang of the noted discrepancies. Mr. Liu Yang informed

QA Inspector a repair procedure will be submitted for the area in question.

During the observation of shop work in progress, this QA Inspector Joe Alaniz noted MT Technician Mr. Ying

Yuantao had performed the MT on tack welds with slag present on South Tower Lift 3 Skin B stiffeners. QA

Inspector issued an incident report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------